



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBBP-1404-1-3
Job Sheet 187057



10921

Part No: RBBP-1404-1-3

Job Qty: 4 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/4/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBBP-1404-1 Rev.2 IPP Rev. A 18.11.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	Large Fab	4 pcs	1/4/19	1/4/19	0.00	1.00	Large Fab - 1	13L
110	QC 9	4 pcs	1/4/19	1/4/19	0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	EZ
							QC 9 - 9	
120	QC 5	4 pcs	1/4/19	1/4/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 16	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 38	
							QC 5 - 42	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	EZ
							QC 5 - 30	
130	Outsource - 13 - Zinc Plating	4 pcs	1/4/19	1/4/19			GRO002-VC	
140	Packaging 2-1 - Receive - B4B	4 pcs	1/4/19	1/4/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	JAN 30 2019
							Packaging 2 - 4 - B4B	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
150	QC 6	4 pcs	1/4/19	0.00 0.00	QC 6 - 16	DAS 38 9-88
					QC 6 - 38	
					QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
160	Packaging 3-1 - Stock - B4B	4 pcs	1/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
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					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	DAS 28 9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
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					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
170	QC 21 - SA	4 pcs	1/4/19	0.00 0.00	QC 21 - SA - 16	DAS 21 9-88
Part Op 100 - Weld as per DWG Descriptions: 130 - Issue P/O 01240 - Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required 140 - Certificate of Conformity is required						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
RBBP-1404-1-5	Bolt, Modified	4 pcs (1 ea)	100-Large Fab	514327		
RBBP-1404-1-7	Eye	4 pcs (1 ea)	100-Large Fab	5141908		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Large Fab	RBBP-1404-1-5 GA	4	0	0		
	RBBP-1404-1-7 GA111D	4	0	0		
Part Specifications						
Specifications could not be found.						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

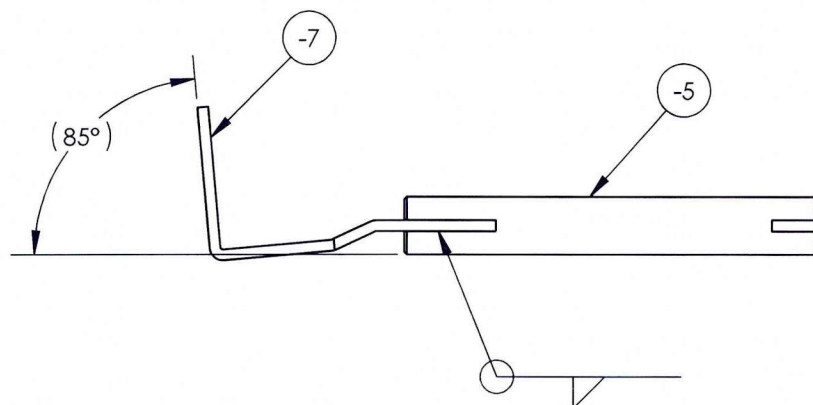
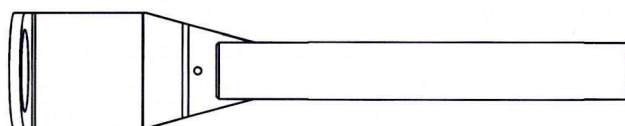
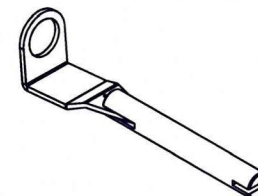
QA Closed: _____ Date: _____

Work Order update only ☐

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This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0025	-3 CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE.	2/8/2016	RJC	JAG



(-3)
WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187057-405
1871-27

DART AEROSPACE	
TITLE K-FLEX DRIVE SHAFT TOOL	
DWG NO. RBBP-1404-1-3	REV 2
MAT'L ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .03 ANGLES ± 1°
SPEC ASTM B633 TYPE I SC 2	.X ± .1 SURFACES = 125 ✓
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 206B
SCALE 1:1	DATE 1/14/2011
SHEET 3 OF 5	

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S146560



Part: RBBP-1404-1-3

Job No: 187057

Serial No/Batch: S146560

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 01/22/19



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042400



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042400

PO Date: 1/25/19

Due Date: 1/28/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments: Is it possible to have these for Monday?
Please advise**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184999	RBE105-31702W23-7	Measuring Flange RH Assembly -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/28/19	2 pcs	0 pcs	2 pcs	\$15.00/pcs	\$30.00
2	187488	RBW109-3101-75-101	Wrench, Flight Controls Servo Actuator Joint Removal/Installation -Issue P/O; -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/28/19	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
3	187057	RBBP-1404-1-3	Weldment -Issue P/O ; -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed	-	1/28/19	4 pcs	0 pcs	4 pcs	\$15.00/pcs	\$60.00
Grand Total:											\$180.00

DAS
38
9-89



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042400



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/25/19 3:38 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016311-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016311- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courrier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
29-Jan-2019		Jessie Boisvert			042400 ✓				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE105-31702W23-7 ✓ Rev.	RBE105-31702W23-7 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	2	2 ✓	0	0	0	
2	RBW109-3101-75-101 ✓ Rev.	RBW109-3101-75-101 01 -ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours ASTM B633 TYPE 2 SC2	ZINC CH	6	6 ✓	0	0	0	
3	RBBP-1404-1-3 ✓ Rev.	RBBP-1404-1-3 01 -ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS ASTM B633 TYPE 1 SC2	ZINC CH	4	4 ✓	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.